



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D4775-041

Job Sheet 189546



008625

Part No: D4775-041

Job Qty: 24 pcs

Part Name: Strut Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/27/19

Job Tracking No:

Due Date: 2/8/19 March 20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C SHEET 1 IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS IPP REV:B 13.08.26 PB1 DD
VERF:JLM IPP REV:C 13.09.26 AS PER REV.B DD VERF:JLM IPP REV:D 14.01.10 AS PER REV.C DD
VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	24 pcs	2/8/19		0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		DAS
							Packaging 1 - 3		28
							Packaging 1 - 4		9-89
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		



Dart Aerospace Ltd.
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CANADA
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Container No: S162061



Part: D4775-041

Job No: 189546

Serial No/Batch: S162061

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/13/19

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					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	DAS
						53 MAR 14 2019
120 Small Fab - 2 - B4B	24 pcs	2/8/19	0.00 9.96		Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
130 QC 5	24 pcs	2/8/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	MAR 17 2019
					QC 5 - 30	DAS 40 9-89
140 Packaging 3-1 - Stock - B4B	24 pcs	2/8/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	5735780 MAR 15 2019
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	

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					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
150 QC 21 - SA	24 pcs	2/8/19	0.00 0.00		QC 21 - SA - 21	
					QC 21 - SA - 70	DAG
					QC 21 - SA - 53	21 MAR 15 2019

Part Op 110 - (Pick Kit)

Descriptions: 120 - (Small Fab) 1- APPLY PROSEAL ON D4776-1 STRUT AND ASSEMBLE AS PER DWG A/R PROSEAL
 BATCH: _____ 2- ENSURE HELICOIL DOES NOT BLOCK HOLE (SEE NOTE 9)
 130 - (QC5- Inspect part completeness to step on W/O)
 140 - (Identify as per dwg & Stock Location: _____)
 150 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-10A <i>over 003</i>	Bolt	48 Ea (2 ea)	110-Packaging 1 - Pick Kit	<i>5157517</i>
D4775-1 <i>5T357</i>	Strut Tube	24 pcs (1 ea)	110-Packaging 1 - Pick Kit	<i>5151543</i>
D4776-1 <i>5T114</i>	Basket Strut Clevis	24 pcs (1 ea)	110-Packaging 1 - Pick Kit	<i>5152159</i>
D4776-5 <i>5T115</i>	Spacer	96 pcs (4 ea)	110-Packaging 1 - Pick Kit	<i>5151021</i>
D4777-1 <i>5T115</i>	Rod End Bearing	24 pcs (1 ea)	110-Packaging 1 - Pick Kit	<i>20x 5158056 + 4x 5150661</i>
MS21042L3	Nut	48 Ea (2 ea)	110-Packaging 1 - Pick Kit	<i>5130347</i>
MS21209-F615 <i>5T296</i>	Heli-Coil	24 Ea (1 ea)	110-Packaging 1 - Pick Kit	<i>18x 5131187 + 6x 5158088</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	AN3-10A	48	297	0
	D4775-1	24	31	0
	D4776-1	24	31	0
	D4776-5	96	118	0
	D4777-1	24	27	0
	MS21042L3	48	4,022	0
	MS21209-F615	24	159	0

Part Specifications

Specifications could not be found.

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					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	24 Ea		2/8/19	0.00	0.00	Start Up Stores/Pkg-1		
110	Packaging	24 pcs		2/8/19	0.00	0.00	Packaging1-5		
120	Small Fab	24 pcs		2/8/19	0.00	9.96	Small Fab-7		
130	QC	24 pcs		2/8/19	0.00	0.00	QC5		
140	Packaging	24 pcs		2/8/19	0.00	0.00	Packaging3-2		
150	QC21-SA	24 Ea		2/8/19	0.00	0.00	QC21		

Part Op 120 - 1- APPLY PROSEAL ON D4776-1 STRUT AND ASSEMBLE AS PER DWG A/R PROSEAL
Descriptions: BATCH: _____ 2- ENSURE HELICOIL DOES NOT BLOCK HOLE (SEE NOTE 9)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-10A	Bolt	48 Ea (2 ea)	90-Start up Operation	
D4775-1	Strut Tube	24 pcs (1 ea)	90-Start up Operation	
D4776-1	Basket Strut Clevis	24 pcs (1 ea)	90-Start up Operation	
D4776-5	Spacer	96 pcs (4 ea)	90-Start up Operation	
D4777-1	Rod End Bearing	24 pcs (1 ea)	90-Start up Operation	
MS21042L3	Nut	48 Ea (2 ea)	90-Start up Operation	
MS21209-F615	Heli-Coil	24 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-10A	48	147	0
	D4775-1	24	6	0
	D4776-1	24	0	0
	D4776-5	96	26	0
	D4777-1	24	24	0
	MS21042L3	48	1,988	0
	MS21209-F615	24	61	0

Part Specifications
Specifications could not be found.

Plex 1/28/19 7:28 AM Dart.lajeunesse.marie